Work Orde				*108	3890*							Page 1
Revision ID:	D3022-1 Seat Pan		A	Accept	*N900	040	100	)*	Setup	Start Stop	I VI	S1* S2*
Start Date: Required Date: Reference:	10/29/13 10/29/13	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item Customer:							
Approvals:	Process P	lan: Mしゴ	Date: 13-10-29	Tooling:	D	ate:	· 		Run	Start	I <i>Z</i> I	R1*
			Date:			)ate:				Stop	*N	R2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accep Qty	t Rej Qty		Reject Number	Insp. Stamp
Draw Nbr	Re	evision Nbr	The second secon									
D3022	Re	ev B										
*100 *100* Waterjet FLOW CNC Waterj		Dwg Rev:_ Prog Rev:	3	0.00						<i>O</i>		<u>de</u> 13.12.11
			direction along 31.700" *** LES,TRANSFER DRILLED A	AT ASSEMBLY***								
110		QC2- Inspect parts off n	nachine FAI/FAIB	0.00								1
*110* QC Quality Control	•	Memo		0.00				1		<b>&gt;</b> .		13.12.1

Quality Control

DQA:	A: Date:								_					1	AA RT
QA Closed:			Date:			WORK ORDER NON	-C(	ONFO	RMANCE / UP	DATE	W	ork Order up	odate only		AEROSPACE
						DISPOSITION				AGAINST		PARTMENT	· !		
Work Orde	er: _						,					- ·			
						Rework	-		Skid-tube	Crosstube	$\overline{}$		Water Jet	_	Engineering
Part I	No					Scrap	]		Machining	Small Fab		•	d. Eng. Coor.	_	Quality
NCD I	\					Use-as-is		Therr	noforming	Finishing		Rec/Stoi	re/Packaging	4	Other
NCR I	vo					Suspected Unapproved	]		Large Fab	Composite		j	Supplier		· [_]
Root					Desci	ription of work order update		Initial	Actio	on		Sign &		T	
Cause		Date	Step	Qty		or non-conformance	Ch	nief Eng	Descri	otion		Date	Verification	,	QC Inspector
Design						,								丁	
Doc/Data	Ш					·									
Equip/Tooling	Ш														
Handling/Pre	Ш														
Material									ļ						
Operator	Ш						1							ļ	
Offset/Setup	Ш														
Process	Щ														
Supplier															
Training															
Transport	Н														
Unapproved	Ш	<del></del>	<u> </u>												
			<u> </u>				FA	ULT CAT	regory						· · · · · · · · · · · · · · · · · · ·
Landi						General		1		i		7	,-	_	
	$\vdash$	Bending				Bend	<u> </u>	1	Program		_	Outside Dim	<b>—</b>		ressure/Forced
	$\vdash$	Centre No	ot Concer	ntric	-	BOM/Route	$\vdash$	Grain				Over/Under	<b>⊢</b>	_	et-up
	$\vdash$	Cracks	l./n:l-	hai	-	Broken/Damage/Defect	<u> </u>	Hardwa		_		Part Incorred	<b>⊢</b>		emperature/Cure
	-	Crimp/Kir	ik/Rippie	/wave	-	Burrs	<u> </u>	1	ion Incomplete/Unc			Part Lost/Mi	ssing		Veld
	-	Cuffs			-	Countamination	_	1	ions Incomplete/Ur	nclear	-	Part Moved		\^	Vrong Stock Pulled
	_	Crushing Heat Trea	+		-	Countersink	<u> </u>	1	ned/off center			Positioned V	· ·		
	$\vdash$			T l	$\vdash$	Cut Too Short	<u> </u>	Mislabe				Power Loss/	Surge	0	ther
	_	nspection	•	eauı		Drawing Drill Holos	$\vdash$	Misread	i e						
	$\vdash$	Marks/Ch				Drill Holes	$\vdash$	Off-set	- 14 . · ·						
	-	Turning So Wave/Tw		vo	-	Finish Fit/Function	-	4	Calibration						
	. 11	** a v C / 1 W	13E 111 TUU	/ C	1		4	II IIII OT V	SUMMER						

October-29-13				*108	890*		<u>.</u>			Page 2
Item ID: Revision ID: Item Name:	D3022-1 Seat Pan			Accept	*N90004	4 <b>01</b> 0	<b>N</b> *	Setup St		NS1* NS2*
Start Date: Required Date: Reference:	10/29/13 10/29/13	Start Qty: 1.00 Req'd Qty: 1.00	*1°		Cust Item ID: Customer:			- 01		4
Approvals:	Process Pl	an:	Date:	Tooling:	Date:		-		art *	<b>VR1*</b>
	QC:		Date:	SPC (Y/N):	Date:		-	51	.op *	VR2*
Sequence ID/ Work Center II	)	Operation Description		Set Up/ Run Hours.S	Tool ID To	ool # Plan Code	Accept Qty	t Reject Qty	Reject Numb	
*120 *120* QC Quality Control		QC8- Inspect parts - sec  Memo	ond check	0.00 27 9\39 0.00 2 1	16					
130		Bend as per dwg		0.00			ĺ			13/12/
*130* Brake NC Brake NC		Memo		0.00	DAS 30 9-81					
140 * <b>4 4 0</b> *		QC5- Inspect part comp	leteness to step on W	/O 0.00 <b>2</b>			1			•
*140* QC		Memo		0.00 13/12	17		/_	<del></del>	<del></del>	<del></del>

Quality Control

DQA:		_ Date:		<del></del>							TQ AC	
QA Closed:		Date:		WORK ORDER NO	ON-C	ONFO	RMANCE / UPDATE	٠ ۱۸/	ork Order up	ndate only	AEROSPACE	
<del>Q c.oscu.</del>		Dute.								· · ·		
Work Orde	er:			DISPOSITION			AGAII	NST DEPARTMENT/PROCESS				
	****			Rework	(		Skid-tube Crosst	ube		Water Jet	Engineering	
Part N	lo			Scrap	<u>, П</u>		Machining Small	<b></b>	-	d. Eng. Coor.	Quality	
				Use-as-is		Thern	noforming Finish		Rec/Sto	re/Packaging	Other	
NCR N	10			<ul> <li>Suspected Unapproved</li> </ul>	Suspected Unapproved Large Fab		Large Fab Compo	Composite Supp		Supplier	] []	
Root				Description of work order upda	ate	Initial	Action		Sign &			
Cause	Date	Step	Qty	or non-conformance		ief Eng	1		Date	Verification	QC Inspector	
Design												
Doc/Data												
Equip/Tooling				·	1							
Handling/Pre												
Material												
Operator												
Offset/Setup					1.	•						
Process												
Supplier												
Training												
Transport												
Unapproved			<u> </u>	.2 .								
					FA	ULT CAT	regory					
Landi	ng Gear			General					_			
	Bending			Bend		Folio/F	rogram		Outside Dim	ensions	Pressure/Forced	
	Centre N	ot Concer	ntric	BOM/Route		Grain		L	Over/Under	tolerance	Set-up	
	Cracks			Broken/Damage/Defect		Hardwa	re		Part Incorred	ct	Temperature/Cure	
		nk/Ripple	/Wave	Burrs		Inspect	ion Incomplete/Unqualified		Part Lost/Mi	ssing	Weld	
	Cuffs			Contamination		1	ions Incomplete/Unclear		Part Moved		Wrong Stock Pulled	
	Crushing			Countersink		Misalig	ned/off center	L	Positioned V	Vrong		
	Heat Tre			Cut Too Short		Mislabe	eled		Power Loss/	Surge	Other	
		n Strip in	Tube	Drawing		Misread	d .					
	Marks/Cl			Drill Holes		Off-set						
		Sequence		Finish		Out of (	Calibration					
	Wave/Tv	vist in Tub	oe .	Fit/Function		Out of	Sequence					

Page 3

Work Order ID 108890 October-29-13 10:13:07 AM Item ID: D3022-1 Accept \*N900040100\* **Revision ID:** Seat Pan Item Name: 10/29/13 Start Oty: 1.00 **Start Date: Cust Item ID:** Required Date: 10/29/13 Req'd Qty: 1.00 **Customer:** Reference: Run Process Plan: \_\_\_\_\_ Date: \_\_\_\_ Tooling: Approvals: Date: Stop Date: QC:\_\_\_\_ SPC (Y/N): Date: Sequence ID/ Reject Operation Set Up/ **Tool ID** Tool # Plan Accept Reject Insp. Work Center ID Description **Run Hours** Code Qty Qty Number Stamp Identify as per dwg & Stock Location: WAOU 0.00 200 1 12 13-12-18 \*200\* 0.00 Packaging Memo Packaging QC21- Final Inspection - Work Order Release 0.00 \*210\*

0.00

Memo

Quality Control

1\_13/12/18 \_\_\_\_ MF 13-12-18

DQA:		_ Date:										TO A DT
					WORK ORDER NON-	-CC	ONFO	RMANCE / UPD/	ATE			AEROSPACE
QA Closed:		Date:					·		W	ork Order up	date only	
Work Orde	er:				DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
					Rework			Skid-tube C	rosstube	•	Water Jet	Engineering
Part N	٠ ١٥.				Scrap		!	<b>⊢</b>	Small Fab	Pro	d. Eng. Coor.	Quality
					Use-as-is		Thern	noforming	Finishing	4	e/Packaging	Other
NCR N	No			<del></del>	Suspected Unapproved			Large Fab Co	omposite	]	Supplier	
Root				Desci	ription of work order update		nitial	Action		Sign &		
Cause	Date	Step	Qty		or non-conformance	l	ief Eng		on	Date	Verification	QC Inspector
Design								•	•			
Doc/Data												
Equip/Tooling								1				
Handling/Pre								,				
Material												
Operator												
Offset/Setup												
Process										•		
Supplier												
Training												
Transport			-									
Unapproved			ļ	<u> </u>								
						FAL	JLT CAT	TEGORY				-
Landir	ng Gear			_	General				_	•		_
	Bending			<u> </u>	Bend	Щ		Program	·	Outside Dim	ensions	Pressure/Forced
		Not Conce	ntric	<u> </u>	BOM/Route		Grain			Over/Under	tolerance	Set-up
	Cracks			<u> </u>	Broken/Damage/Defect		Hardwa	ire		Part Incorred	t	Temperature/Cure
		ink/Ripple	e/Wave	<u> </u>	Burrs		Inspect	ion Incomplete/Unqua	lified	Part Lost/Mi	· · · · · · · · · · · · · · · · · · ·	Weld
	Cuffs			<u> </u>	Contamination	-		tions Incomplete/Uncle	ear	Part Moved		Wrong Stock Pulled
	Crushing	_		ļ	Countersink	-		gned/off center		Positioned W	/rong	-
	Heat Tre			<u> </u>	Cut Too Short		Mislabe			Power Loss/S	Surge	Other
		on Strip in	Tube	<u> </u>	Drawing	$\vdash$	Misread					
	Marks/0			<u> </u>	Drill Holes	$\vdash$	Off-set					
		Sequence			Finish	⊢—		Calibration				
ĺ	IWave/T	wist in Tub	ne .	l	Fit/Function	1 1	Out of 9	Seguence				

Required Date: 10/29/13

Required Qty: 1.00

Start Date: 10/29/13 Start Qty: 1.00

## **Picklist Print**

October-29-13 10:13:07 AM

Work Order ID:

108890

Parent Item:

Comments:

D3022-1

Parent Item Name:

Seat Pan

IPP C02.01.23Revised

IPP Rev:D 08-04-16 now water jet DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
<b>M2024T3S.032</b> 2024-T3 .032 sheet		Purchased	No			100	sf	500.4612	1.6232	2	9	k 13	5.12.
				Location		Loc Qty	Lo	c Code					
				MAT022		500.4612							
				1182	43	32.3562							
•				1185	23	141							
				1213	09	64.656			***				
				1230	96	27.6							
				1235	74	. 81.9							
				1249	87	152.949							

DQA:		- Date:			WORK OPDER NON	~	281501	DA444105 / LIDDATS				
QA Closed:		Date:			WORK ORDER NON-	-((	JNFO	RIVIANCE / UPDATE	W	ork Order up	odate only	AEROSPACE
Work Orde	or:				DISPOSITION			AGAINS	T DE	PARTMENT	/PROCESS	
Part N	No				Rework Scrap Use-as-is Suspected Unapproved		Skid-tube Crosstube  Machining Small Fab  Thermoforming Finishing  Large Fab Composite		b g	4	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
					Suspected Onapproved			composit	е <u>Г</u>	į	Supplier	J
Root Cause	Date	Step	Qty	Desci	ription of work order update or non-conformance		Initial rief Eng	Action Description		Sign & Date	Verification	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved												•
		•				FAL	ULT CAT	TEGORY				
Landir	Cracks	at n Strip in natter	/Wave		General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish		Grain Hardwa Inspecti Instruct Misalig Mislabe Misread Off-set	on Incomplete/Unqualified ions Incomplete/Unclear ned/off center led		Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned W Power Loss/S	tolerance ct ssing	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other
	Wave/Tw		e	<del></del>	Fit/Function	_	1	Sequence				

DART AEROSPACE LTD	Work Order:	10 8890
Description: Seat Pan	Part Number:	D3022-1
Inspection Dwg: D3022 Rev: B		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
14.75	+/-0.030	14.75	_		7	1Km-06
12.28	+/-0.030	12.28			T	
2.72	+/-0.030	272	_		V	JKM-OL JKM-OS
14.62	+/-0.030	14.62	_		T	
12.15	+/-0.030	18.15			十	
•						
						·
				DAS-		

Measured by:	Audited by:	9-89	Preliminary Approval:	
Date: 13.12.11	Date:	13/12/16	Date:	

Rev	Date	Change	Revised by	Approved
Α	08.06.13	New Issue	KJ/DD IN	11/
В	11.06.21	Dwg Rev updated	KJ 🙀	





